

Work Order ID 58287-2 *Split*

May 3, 2010 10:25:04 AM

Page 1

Item ID: D2565-101

Revision ID:

Item Name: Strut

Start Date: 5/03/10

Start Qty: 40.00 *7*

Required Date: 5/05/10

Req'd Qty: 10.00

Reference:

Approvals:

Process Plan: *BL*

Date: *10-5-02*

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D2565

Rev E

100



Brake NC

Brake NC

NC BRAKE

0.00

Memo

0.00

Punch as per Dwg D2565 using DT 8313

SD 10/05/12

(10)

110



Small Fab

Small Fab

Small Fab

0.00

Memo

0.00

Drill hole open to .316 O as per Dwg D2565 (one end only)

Deburr and

=> m-l 10/05/19

(7X)

120



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

Swab 10/05/19

(47)

Work Order ID 58287

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Item ID: D2565-101

Accept



Setup Start



Revision ID:

Stop



Item Name: Strut

Start Date: 5/03/10

Start Qty: 10.00



Cust Item ID:

Required Date: 5/05/10

Req'd Qty: 10.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel

0.00



Powdercoat

Memo

0.00

Powder Coating

START TIME:

11:30AM

12:00pm

FINISH TIME:

OVEN TEMPERATURE:

400°F

⇒ M 10/05/20

7

Ø

140

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

7 BK 10-5-20.

150

Identify as per dwg & Stock Location

0.00



Packaging

Memo

0.00

Packaging

72

B58287 10-5-25 ✓

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Item ID: D2565-101

Accept



Setup Start



Revision ID:

Stop



Item Name: Strut

Start Date: 5/03/10 Start Qty: 10.00



Cust Item ID:

Required Date: 5/05/10 Req'd Qty: 10.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/05/26
CL015124

Picklist Print

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Page 1

Work Order ID: 58287

Parent Item: D2565-101

Parent Item Name: Strut

Comments: IPP: F 02.04.16 Added dwg Rev.C1 NG

Start Date: 5/03/10

Required Date: 5/05/10

Start Qty: 10.00

Required Qty: 10.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Qty Issued	Date Issued	Status
M304TR0.750W.049		Purchased	No			100	F	303.4562	1.71			



304 RD Tube .750 x .049W



Location	Loc Qty	Loc Code
MAT	275.5927	
108498	0	
114482	275.5927	
MAT017	27.8635	
109314	9.33	
110113	5.29	
112800	13.2435	

219 SA 05/05/12

DART

DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2565	REV. E SHEET 1 OF 1
DATE 04.05.05		TITLE STRUT	SCALE 1:3
A	96.05.03	NEW ISSUE	
B	97.03.15	CORRECT D2565-111 DIM. A	
C	98.10.05	UPDATED MATERIAL NOTE (TSR A603)	
D	02.06.05	ADD -3XX PARTS; ADD FINISH	
E	04.05.05	ADD D2565-401-411; RMV ANGLE D	

RELEASED
04.05.05 *[Signature]*

SHOP COPY

RETURN TO

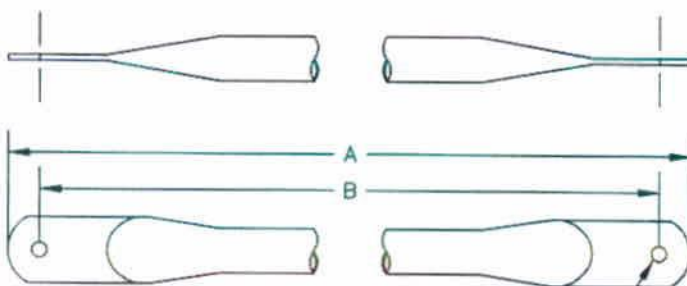
ENGINEERING

UNCONTROLLED COPY

SUBJECT TO AMENDMENT

WITHOUT NOTICE

WORK ORDER

NO. 58287B/ 10-5-03

DIA 0.257 TO BE PUNCHED
"C" DIA TO BE OPENED MANUALLY

PUNCH ENDS PER SPEC CONTROL DRAWING D2638

PART #	A	B	DIA C
D2565-101	20.52	19.72	0.316
D2565-103	18.21	17.41	0.316
D2565-105	20.19	19.39	0.316
D2565-107	13.43	12.63	-
D2565-109	12.31	11.51	-
D2565-111	13.65	12.85	-
D2565-201	22.79	22.00	0.316
D2565-203	20.75	19.95	0.316
D2565-205	21.22	20.42	0.316
D2565-207	16.07	15.27	-
D2565-209	15.16	14.36	-
D2565-211	14.14	13.34	-
D2565-301	27.03	26.23	0.316
D2565-303	25.34	24.54	0.316
D2565-305	23.73	22.93	0.316
D2565-307	20.86	20.06	-
D2565-309	20.17	19.37	-
D2565-311	16.30	15.50	-
D2565-401	18.29	17.49	0.316
D2565-403	15.64	14.84	0.316
D2565-405	19.45	18.65	0.316
D2565-407	10.79	9.99	-
D2565-409	9.34	8.54	-
D2565-411	13.81	13.01	-

GENERAL NOTES

- 1) MATERIAL: AISI 304/316/318 SS 0.750 OD X 0.049 WALL
(REF DART SPEC. M304TR0.750W0.049)
ENSURE SEAMLESS TUBE IS USED
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES

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W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries